

Work Order ID 143579

143579

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March 16, 2016 11:48:48 AM

Item ID: D412-704-011

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Co-Pilot's Emergency Cargo Release

Start Date: 4/15/2016 Start Qty: 3.00

3

Cust Item ID:

Required Date: 4/26/2016 Req'd Qty: 3.00

3

Customer:

Reference:

Approvals:

Process Plan: SU

Date: **20160316**

Pooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D412-704	D								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile and create labels per PPP D412-704-011 CHG003								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									

DAS
6
9-89

DAS
27
9-89

APR 26 2016

DAS
6
9-89

DAS
28
9-89

APR 27 2016

DAS
27
9-89

APR 26 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	

Root Cause				FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐		
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐		
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐		
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐		
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐		
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐		
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐		
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐		
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐		
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐		
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____					
Misidentified ☐	Past Due ☐						

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Item ID: D412-704-011

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N900040100Setup Start ***NS1***

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Cust Item ID:

Required Date: 4/26/2016 Req'd Qty: 3.00

3

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00				3	5m	16/4/25	
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D412-704-011 Location : FG 018								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.01							
Quality Control									

APR 27 2016

APR 27 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

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Work Order ID: 143579

143579

Parent Item: D412-704-011

D412-704-011

Parent Item Name: Co-Pilot's Emergency Cargo Release

Start Date: 4/15/2016

Required Date: 4/26/2016

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP Rev:B05.01.28Hardware added to Step 3KJ/RF
IPP Rev:C05.12.21Hardware removed on Step 3 EC IPP REV:D AS
PER REV C JLM VERIFIED BY:EC
IPP REV:E 12.05.10 per ECN 12-583 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D412-704-041 *D412-704-041* Pedal Ass'Y		Manufactured	No			110	Each	0.0000	1	3			DAS 6 9-89
D412-704-045 *D412-704-045* Cable Ass'Y		Manufactured	No			110	Each	0.0000	1	3			DAS 6 9-89
D3207-5 *D3207-5* Bracket		Manufactured	No			110	Each	13.0000	1	3			DAS 6 9-89
Location ST024 116991 Loc Qty 13 13 Loc Code													
D3207-7 *D3207-7* Packer		Manufactured	No			110	Each	12.0000	1	3			DAS 6 9-89
Location ST024 110077 Loc Qty 12 12 Loc Code													
D3207-11 *D3207-11* Bracket		Manufactured	No			110	Each	2.0000	1	3			DAS 6 9-89
Location ST024 125242 Loc Qty 2 2 Loc Code													

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Work Order ID: 143579

143579

Parent Item: D412-704-011

D412-704-011

Parent Item Name: Co-Pilot's Emergency Cargo Release

Start Date: 4/15/2016

Required Date: 4/26/2016

Start Qty: 3.00

Required Qty: 3.00

D3208-1	Manufactured	No	110	Each	1.0000	1	3	DAS 6 9-89	DAS 28 9-89
D3208-1									
Doubler									
DAS 27 9-89									
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
			ST025	1					
			124260	1					
D3208-11	Manufactured	No	110	Each	22.0000	1	3	DAS 6 9-89	DAS 28 9-89
D3208-11									
Filler									
DAS 27 9-89									
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
			ST026	22					
			141386	22					
D3208-3	Manufactured	No	110	Each	6.0000	1	3	DAS 6 9-89	DAS 28 9-89
D3208-3									
Pedal Mount Angle									
DAS 27 9-89									
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
			ST025	6					
			117181	6					
D3208-7	Manufactured	No	110	Each	7.0000	1	3	DAS 6 9-89	DAS 28 9-89
D3208-7									
Filler									
DAS 27 9-89									
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
			ST025	7					
			119559	7					
D3208-9	Manufactured	No	110	Each	18.0000	1	3	DAS 6 9-89	DAS 28 9-89
D3208-9									
Doubler									
DAS 27 9-89									
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
			ST025	18					
			142241	18					

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Parent Item: D412-704-011

D412-704-011

Parent Item Name: Co-Pilot's Emergency Cargo Release

Start Date: 4/15/2016

Required Date: 4/26/2016

Start Qty: 3.00

Required Qty: 3.00

D3214-1

Manufactured No

110

Each

0.0000

1 3

DAS
28
9-89

D3214-1

Decal

MS21919-DG5

Purchased No

110

Each

40.0000

4 12

DAS
28
9-89

MS21919-DG5

Clamp

DAS
28
9-89

Location

Loc Qty

Loc Code

over008

30

m134134

30

ST293

10

m133938

10

DAS
27
9-89

APR 20 2016

5.0 PARTS LIST

Qty -011	Qty -013	Qty -015	Qty -041	Qty -141	Qty -043	Qty -045	Part Number	Description
X							D412-704-011	COPILOT'S EMERGENCY CARGO RELEASE KIT (210/212/214)
	X						D205-704-013	COPILOT'S EMERGENCY CARGO RELEASE KIT (205)
		X					D412-704-015	COPILOT'S EMERGENCY CARGO RELEASE KIT (412)
1	1		X				D412-704-041	PEDAL ASSEMBLY (205/210/212/214)
		1		X			D412-704-141	PEDAL ASSEMBLY (412)
	1				X		D205-704-043	CABLE ASSEMBLY (205)
1		1				X	D412-704-045	CABLE ASSEMBLY (210/212/214/412)
			1	1			D3204-041	PEDAL ASSEMBLY (OR ECM 999702-1)
			1	1			D3205-1	PEDAL BRACKET (OR ECM 999703-1)
			1	1			D3205-3	BACK PLATE (OR ECM 999709-5)
			1	1			D3206-1	PEDAL ARM (OR ECM 999704-1)
	1						D3207-1	BRACKET
	1						D3207-3	BRACKET
1		1					D3207-5	BRACKET
1	1	1					D3207-7	PACKER
		1					D3207-9	BRACKET
1							D3207-11	BRACKET
1	1	1					D3208-1	DOUBLER (OR ECM 999709-1)
1	1	1					D3208-3	PEDAL MOUNT ANGLE (OR ECM 999709-7)
	1						D3208-5	MOUNT ANGLE
1	1	1					D3208-7	FILLER (OR ECM 999709-3)
1		1					D3208-9	DOUBLER
1		1					D3208-11	FILLER
			1	1			D3209-041	BRACKET ASSEMBLY (OR BHT 204-070-993-001)
1	1	1					D3214-1	PLACARD (OR ECM 999712-1)
					1		D3217-1	CABLE
						1	D3217-3	CABLE
					1	1	D3257-1	FITTING
					1	1	D3258-1	ANGLE BRACKET
		1					D4610-1	DOUBLER
		1					D4610-3	DOUBLER
			1	1			D4610-5	SHIM
		1					D4610-7	COVER
				1			D4611-1	BUSHING
		1					D4622-1	PLACARD
		1					D4622-3	PLACARD
			1	1	1	1	AN3-10A	BOLT
			1	1			AN315-4R	NUT
					1	1	AN3-5A	BOLT
			2	2			AN3-6A	BOLT
			1	1			AN4-10A	BOLT
			2				AN4-11A	BOLT
				2			AN4-12A	BOLT
			1				AN4-13A	BOLT
				1			MS20002-4	WASHER

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Revision: D
 Date: 14.12.02

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IIN-D412-704

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Qty -011	Qty -013	Qty -015	Qty -041	Qty -141	Qty -043	Qty -045	Part Number	Description
				1			MS20004-24	BOLT
			3	3	2	2	MS21042L3	NUT (OR MS21042-3)
			5	5			MS21042L4	NUT (OR MS21042-4)
4	4	4					MS21919DG5	CLAMP
			1				MS24694-S102	SCREW
				1			MS24694-S104	SCREW
	2						MS35489-10	GROMMET
		1					MS35489-149	GROMMET
			1	1			MS9519-10	BOLT
			4	4	2	2	NAS1149D0332J	WASHER (OR AN960JD10L)
			5	5	2	2	NAS1149D0363J	WASHER (OR AN960JD10)
			3	2			NAS1149D0416J	WASHER (OR AN960JD416L)
			14	13			NAS1149D0463J	WASHER (OR AN960JD416)
					3	3	NAS509-3	NUT

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